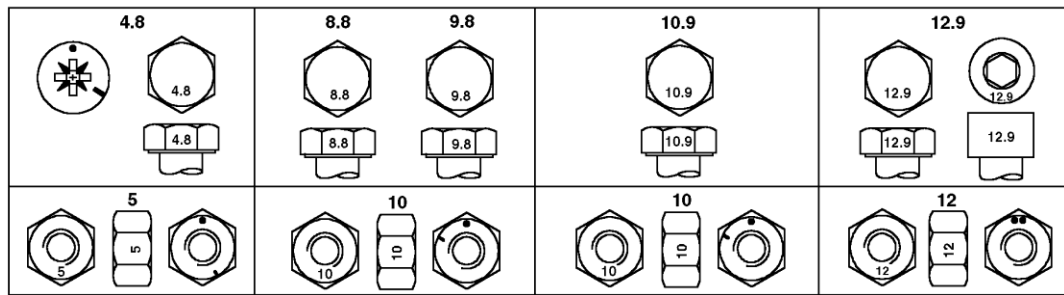


## Metric Bolt and Cap Screw Torque Values



Top, Property Class and Head Markings; Bottom, Property Class and Nut Markings

	Class 4.8		Class 8.8 or 9.8		Class 10.9		Class 12.9	
Size	Lubricated <sup>a</sup> N·m (lb-ft)	Dry <sup>b</sup> N·m (lb-ft)	Lubricated <sup>a</sup> N·m (lb-ft)	Dry <sup>b</sup> N·m (lb-ft)	Lubricated <sup>a</sup> N·m (lb-ft)	Dry <sup>b</sup> N·m (lb-ft)	Lubricated <sup>a</sup> N·m (lb-ft)	Dry <sup>b</sup> N·m (lb-ft)
M6	4.7 (3.5)	6 (4.4)	9 (6.6)	11.5 (8.5)	13 (9.5)	16.5 (12.2)	15.5 (11.5)	19.5 (14.5)
M8	11.5 (8.5)	14.5 (10.7)	22 (16)	28 (20.5)	32 (23.5)	40 (29.5)	37 (27.5)	47 (35)
M10	23 (17)	29 (21)	43 (32)	55 (40)	63 (46)	80 (59)	75 (55)	95 (70)
M12	40 (29.5)	50 (37)	75 (55)	95 (70)	110 (80)	140 (105)	130 (95)	165 (120)
M14	63 (46)	80 (59)	120 (88)	150 (110)	175 (130)	220 (165)	205 (150)	260 (190)
M16	100 (74)	125 (92)	190 (140)	240 (175)	275 (200)	350 (255)	320 (235)	400 (300)
M18	135 (100)	170 (125)	265 (195)	330 (245)	375 (275)	475 (350)	440 (325)	560 (410)
M20	190 (140)	245 (180)	375 (275)	475 (350)	530 (390)	675 (500)	625 (460)	790 (580)
M22	265 (195)	330 (245)	510 (375)	650 (480)	725 (535)	920 (680)	850 (625)	1080 (800)
M24	330 (245)	425 (315)	650 (480)	820 (600)	920 (680)	1150 (850)	1080 (800)	1350 (1000)
M27	490 (360)	625 (460)	950 (700)	1200 (885)	1350 (1000)	1700 (1250)	1580 (1160)	2000 (1475)
M30	660 (490)	850 (625)	1290 (950)	1630 (1200)	1850 (1350)	2300 (1700)	2140 (1580)	2700 (2000)
M33	900 (665)	1150 (850)	1750 (1300)	2200 (1625)	2500 (1850)	3150 (2325)	2900 (2150)	3700 (2730)
M36	1150 (850)	1450 (1075)	2250 (1650)	2850 (2100)	3200 (2350)	4050 (3000)	3750 (2770)	4750 (3500)

<sup>a</sup> "Lubricated" means coated with a lubricant such as engine oil, or fasteners with phosphate and oil coatings.

<sup>b</sup> "Dry" means plain or zinc plated without any lubrication.

DO NOT use these values if a different torque value or Make sure fastener threads are clean and that you tightening procedure is given for a specific application. properly start thread engagement. This will prevent

Torque values listed are for general use only. Check tightness of fasteners periodically.

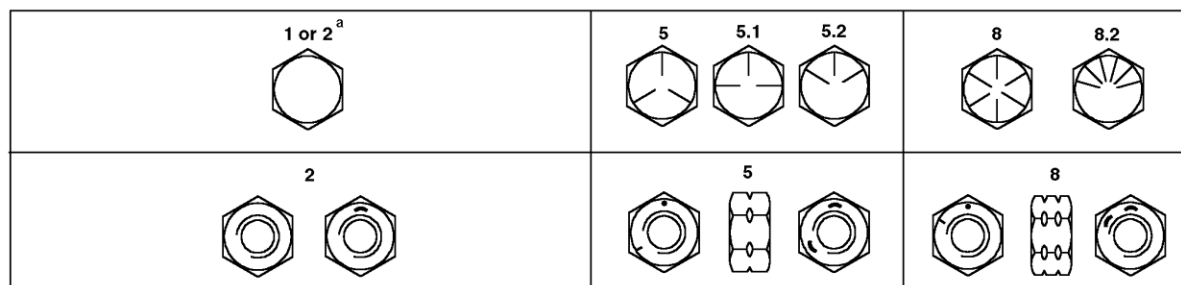
Shear bolts are designed to fail under predetermined loads. Always replace shear bolts with identical property class.

Fasteners should be replaced with the same or higher property class. If higher property class fasteners are used, these should only be tightened to the strength of the original.

them from failing when tightening.

Tighten crimped steel-type lock nuts to the dry torque shown in the chart, applied to the nut, not to the bolt head.

## Unified Inch Bolt and Cap Screw Torque Values



Top, SAE Grade and Head Markings; Bottom, SAE Grade and Nut Markings

	Grade 1 (No Mark)		Grade 2 <sup>a</sup> (No Mark)		Grade 5, 5.1 or 5.2		Grade 8 or 8.2	
Size	Lubricated <sup>b</sup> N·m (lb-ft)	Dry <sup>c</sup> N·m (lb-ft)	Lubricated <sup>b</sup> N·m (lb-ft)	Dry <sup>c</sup> N·m (lb-ft)	Lubricated <sup>b</sup> N·m (lb-ft)	Dry <sup>c</sup> N·m (lb-ft)	Lubricated <sup>b</sup> N·m (lb-ft)	Dry <sup>c</sup> N·m (lb-ft)
1/4	3.8 (2.8)	4.7 (3.5)	6 (4.4)	7.5 (5.5)	9.5 (7)	12 (9)	13.5 (10)	17 (12.5)
5/16	7.7 (5.7)	9.8 (7.2)	12 (9)	15.5 (11.5)	19.5 (14.5)	25 (18.5)	28 (20.5)	35 (26)
3/8	13.5 (10)	17.5 (13)	22 (16)	27.5 (20)	35 (26)	44 (32.5)	49 (36)	63 (46)
7/16	22 (16)	28 (20.5)	35 (26)	44 (32.5)	56 (41)	70 (52)	80 (59)	100 (74)
1/2	34 (25)	42 (31)	53 (39)	67 (49)	85 (63)	110 (80)	120 (88)	155 (115)
9/16	48 (35.5)	60 (45)	76 (56)	95 (70)	125 (92)	155 (115)	175 (130)	220 (165)
5/8	67 (49)	85 (63)	105 (77)	135 (100)	170 (125)	215 (160)	240 (175)	305 (225)
3/4	120 (88)	150 (110)	190 (140)	240 (175)	300 (220)	380 (280)	425 (315)	540 (400)
7/8	190 (140)	240 (175)	190 (140)	240 (175)	490 (360)	615 (455)	690 (510)	870 (640)
1	285 (210)	360 (265)	285 (210)	360 (265)	730 (540)	920 (680)	1030 (760)	1300 (960)
1-1/8	400 (300)	510 (375)	400 (300)	510 (375)	910 (670)	1150 (850)	1450 (1075)	1850 (1350)
1-1/4	570 (420)	725 (535)	570 (420)	725 (535)	1280 (945)	1630 (1200)	2050 (1500)	2600 (1920)

1-3/8	750 (550)	950 (700)	750 (550)	950 (700)	1700 (1250)	2140 (1580)	2700 (2000)	3400 (2500)
1-1/2	990 (730)	1250 (930)	990 (730)	1250 (930)	2250 (1650)	2850 (2100)	3600 (2650)	4550 (3350)

<sup>a</sup> *Grade 2 applies for hex cap screws (not hex bolts) up to 6 in. (15.2 cm) long. Grade 1 applies for hex cap screws over 6 in. (15.2 cm) long, and for all other types of bolts and screws of any length.*

<sup>b</sup> *"Lubricated" means coated with a lubricant such as engine oil, or fasteners with phosphate and oil coatings.*

<sup>c</sup> *"Dry" means plain or zinc plated without any lubrication.*

DO NOT use these values if a different torque value or tightening procedure is given for a specific application. Torque values listed are for general use only. Check tightness of fasteners periodically.

Make sure fastener threads are clean and that you properly start thread engagement. This will prevent them from failing when tightening.

Shear bolts are designed to fail under predetermined loads. Always replace shear bolts with identical grade.

Tighten crimped steel-type lock nuts to the dry torque shown in the chart, applied to the nut, not to the bolt head.

Fasteners should be replaced with the same or higher grade. If higher grade fasteners are used, these should only be tightened to the strength of the original.